

WORK ORDER

2008-25

Date opened:

8 December 2008

Project:

High Mounted Quick Release Cargo Basket Assembly

Type:

Bell 206L Series, 407

Batch Quantity:

3 Complete Basket Assemblies (76610-01)

All with Auxiliary Latch Installation (70403)

Approval:

SH00-48

Drawing List:

DCL766-2

Fabrication and Assembly Drawing(s)Description

76610, Rev. 0

Basket Ass'y

76611, Rev. 0

Basket Body Ass'y

60632, Rev. 0

Basket Lid Ass'y

36255, Rev. 1

Handle Installation

36261, Rev. 1

Handle Bar Ass'y

36262, Rev. 1

Handle Bracket Ass'y

70403, Rev. 0

Auxiliary Latch Installation

Complete material tracking information on attached pages.

Work Order pre-completion Inspection:

Project is on Approval Limitation Record:

Y ✓

Document Control List revision level matches (or exceeds) STC:

Y ✓

Drawings revision levels match Document Control List:

Y ✓

Purchase order or Work order source is recorded for each part/ass'y:

Y ✓

Tests and inspections specifically called out on drawings are complete:

Y ✓

Release tags associated with all fabricated parts are attached:

Y ✓

All mounting hardware and supplies are included:

Y ✓

List all non-conformities raised:

Inspector Signature:

Date:

Drawing: 76610 Revision 0
 Assembly: 76610-01 Cargo Basket Ass'y (Quick-Release, High Mounted)

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
3 Total	76610-01	Cargo Basket Assembly			
1	76611-01	Basket Body Assembly	Below		
1	60632-01	Basket Lid Assembly	Below		
1	36255-01	Handle Bar Installation	Below		
1	36280-01	Brace Assembly	9-2081 Brace	7005	
1	MS20001P4	Piano Hinge		8024	
1	76625-01	Placard	0.063" Sheet, 6061-T6 Aluminum	960708	
3	49205-14	Bumper	Argus Industries Bumper	8071	
A/R	CR3213-4-02	Cherry Rivet		8034	
4	40088-14	Fitting	Ancra	8032	
4	AN960-616	Washer		6016	
1	AN3-15A	Bolt		6016	
1	AN3-17A	Bolt		6066	
4	AN960-10	Washer		6043	
2	AN970-3	Washer		5026	
2	MS21044N3	Nut		6016	

Processes	Per	Mat'l's Used	Inspection	Signature
Riveting	AC43.13-1B	CR3213-4-02 Rivets		JC.
Final Inspection	Drawing 76610			JC.

Tag incomplete parts with Work Order # when stored between processes.

Tag complete parts / assemblies with Release Tag prior to storage.

Drawing: 76611 Revision 1
 Assembly: 76611-01 Basket Body Ass'y (High Mounted Quick-Release)

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
3 Total	76611-01	Basket Body Assembly			
1	76621-01	End Hoop	4130 Steel, 1/2" x 0.035 Sqr. Tube	8007	
4	76623-01	Hoop	4130 Steel, 1/2" x 0.035 Sqr. Tube	8007	
1	76622-01	Hoop	4130 Steel, 1/2" x 0.035 Sqr. Tube	8007	
2	60640-01	Rim	4130 Steel, 3/4" x 0.035 Sqr. Tube	8007	
2	49212-01	Rim	4130 Steel, 3/4" x 0.035 Sqr. Tube	8007	
5	60643-01	Spine	4130 Steel, 1/2" x 0.035 Sqr. Tube	8007	
1	36262-01	Handle Bracket Assembly	Below		
1	49215-01	Spacer	1018 Steel, 1/2" Rod	951108	
A/R	3/4-16F	Mesh	Expanded carbon steel	7029	

Processes	Per	Mat'ls Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ER70S-2		
Powder Coat	Drawing 76611			
Final Inspection	Drawing 76611			

Tag incomplete parts with Work Order # when stored between processes.

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Drawing: 60632 Revision 0
 Assembly: 60632-01 Basket Lid Ass'y (High Mounted Quick-Release)

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
3 Total	60632-01	Basket Lid Assembly			
2	60640-01	Rim	4130 Steel, 3/4" x 0.035 Sqr. Tube	8007	
2	49212-01	Rim	4130 Steel, 3/4" x 0.035 Sqr. Tube	8007	
4	49213-01	Lid Brace	4130 Steel, 3/4" x 0.035 Sqr. Tube	8007	
1	49216-01	Spacer	1018 Steel, 1/2" Rod	951108	
1	36262-01	Upper Handle Bracket Assembly	Below		
1	36204-10	Placard Bracket	1018 Steel, 0.035" Sheet	9516042	
A/R	3/4-16F	Mesh	Expanded carbon steel	7029	
6	60649-01	Step Brace	4130 Steel, 3/4" x 0.035 Sqr. Tube	8007	
A/R	60632-10	Tread Plate	3003 Aluminum, 0.063 tread sheet	7058	

Processes	Per	Mat'ls Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ER70S-2		
Powder Coat	Drawing 60632			jc
Final Inspection	Drawing 60632			jc.

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Drawing: 36255 Revision 1
Assembly: 36255-01 Handle Installation

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
3 Total	36255-01	Handle Installation			
1	36261-01	Handle Bar Assembly	Below		
2	36278-01	Spring (1 left, 1 right)	304 Stainless, 1/16" Dia Music Wire	7004	
2	36275-01	Bushing	SAE 660 Bronze, 5/16" Dia	6068	
2	AN3-14A	Bolt		6071	
4	AN960-10	Washer		6043	
2	MS21044N3	Nut		6016	

Processes	Per	Mat'ls Used	Inspection	Signature
Final Inspection	Drawing 36255			gc.

Tag incomplete parts with Work Order # when stored between processes.

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Drawing: 36261 Revision 1
Assembly: 36261-01 Handle Bar Assembly

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
3 Total	36261-01	Handle Bar Assembly			
1	36277-01	Handle Bar	316 Stainless, 1.0 x 0.035 Rnd. Tube	8066	
2	36271-01	Lever	304 Stainless, 0.105 Sheet	7006	
2	36274-01	Bushing	304 Stainless, 7/16" x 0.065 Rnd. Tube	2005	
2	MS20615-4M3	Rivet		7039	


Processes	Per	Mat'ls Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ER308L		
Final Inspection	Drawing 36261			JC

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Drawing: 36262 Revision 1
Assembly: 36262-01 Handle Bracket Assembly

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
3 Total	36261-01	Handle Bracket Assembly			
1	36272-01	Basket Bracket	321 Stainless, 0.050 Sheet	3021	
2	36273-01	Lid Bracket	321 Stainless, 0.050 Sheet	3021	
2	36275-02	Support	304 Stainless, 5/16" Rod	6003	

Processes	Per	Mat'ls Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ER308L		
Final Inspection	Drawing 36262			


Tag incomplete parts with Work Order # when stored between processes.

Tag complete parts / assemblies with Release Tag prior to storage.

Drawing: 70403 Revision 0
Assembly: 70403-01 Auxiliary Latch Modification


Qty Per	Part #	Description	Material	P.O./W.O.	Checked
3 Total	70403-01	Auxiliary Latch Modification			
2	60650-04	Tab	321 Stainless Steel, 0.032 Sheet	3021	
2	60650-05	Insert	1018 Steel, 0.375 Rod	951108	
1	60650-06	Bushing	Brass, 0.25 Rod	7047	
1	0115-306	Latch Cord	Arctic Cat	8046	
1	0115-307	Latch Cup	Arctic Cat	8046	
1	AN3-10A	Bolt		6071	
2	AN960-10	Washer		6016	
1	MS21044N3	Nut		6016	
2		#8-32 Screw	Stainless steel, commercial		

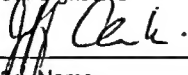
Note: Remainder of assembly listed on drawing 76611 and 60632

Processes	Per	Mat'ls Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ER70S-2		
Final Inspection	Drawing 70403			

Tag incomplete parts with Work Order # when stored between processes.

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1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No.
4. Organization Name and Address AERO Design Ltd. – 2013 39th Avenue NE, Calgary, Alberta, T2E 6R7					5. Work Order/Contract/Invoice 2008-25
6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work
	High Cargo Basket	76610-01	1	76601-07	New
12. Remarks Modified with lid step and auxiliary latch IAW DCL704					
13a. Certifies that the items identified above were manufactured in conformity to:			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12		
<input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.		
13b. Signature 		13c. Approved Organization Number AMF 73-04		14b. Signature	
13d. Name Jeff Clarke		13e. Date (dd/mmm/yyyy) 22 Dec 2010		14c. Approved Organization Number	
				14d. Name	
				14e. Date (dd/mmm/yyyy)	
Installer Responsibilities This certificate does not constitute authority to install. Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified. Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.					

1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No.
4. Organization Name and Address AERO Design Ltd. – 2013 39 th Avenue NE, Calgary, Alberta, T2E 6R7					5. Work Order/Contract/Invoice WO2008-25
6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work
	High Cargo Basket	76610-01	1	76601-06	New
12. Remarks Modified with lid step and auxiliary latch IAW DCL704.					
13a. Certifies that the items identified above were manufactured in conformity to:			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12		
<input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.		
13b. Signature 		13c. Approved Organization Number AMF 73-04		14b. Signature	
13d. Name Jeff Clarke		13e. Date (dd/mmm/yyyy) 20 Oct 2010		14c. Approved Organization Number	
				14d. Name	
				14e. Date (dd/mmm/yyyy)	
Installer Responsibilities					
This certificate does not constitute authority to install.					
Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.					
Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.					

BULKCO-13

AERO DESIGN LTD.

2013 – 39th Ave N. E., Calgary, Alberta, T2E 6R7

jeff@aerodesign.ca

F A X C O V E R S H E E T

DATE: October 26, 2009

TIME: 10:32 AM

TO: Ted Tapanila

PHONE: 250-963-9884

VIH Helicopters Ltd.

FAX: 250-963-9832

FROM: J. Clarke

PHONE: 403-250-8027

Aero Design Ltd.

FAX: 403-250-8333

Number of pages including cover sheet: 5

RE: BELL 407 HIGH MOUNTED CARGO BASKET

Ted,

Please find attached the release tags for the basket, and the packing slip for the pilot step. Originals will be in the mail.

Regards,



Jeff Clarke

19 October 2009

Address:

VIH Helicopters Ltd.
4275 Hangar Road
Prince George, BC
V2L 4S2

Attention:

Ted Tapanila

Phone #:

250-963-9884

We hereby declare that the parts supplied herein do conform with the referenced drawings. Use and installation of the parts may require further approval, and shall also comply with applicable airworthiness standards.


Signature

Product: Auxiliary Step

Reference: Your Purchase Order #: 96007

Documents Included with this Shipment:

Supplemental Type Certificate	<u>SH00-48</u>	<u>Issue 6</u>
Document Control List	<u>DCL623</u>	<u>Revision 1</u>
Installation Drawing	<u>62301</u>	<u>Revision 1</u>

Parts and Assemblies Included with this Shipment:

Quantity Ordered	Quantity Shipped	Part Number	Description
1	1	62320-01	Auxiliary Step Assembly
2	2	AN4-16A	Bolt
4	4	AN960-416	Washer
2	2	MS21044N4	Nut

AERO Design Ltd.
2013 - 39th Ave. NE
Calgary, AB, T2E 6R7

AUTHORIZED RELEASE CERTIFICATE

TRANSPORT CANADA
TCCA 24-0078
AMF # 73-04

Product: Quick Release Cargo Basket (High Mounted) Part #: 76610-01

Approval #: SH00-48 Serial #: 76601-09

WO #: 2008-25 Quantity: 1

Eligibility: Bell 206L Series / 407 Work Status: Manufactured

Remarks: Lid Step and Auxiliary Latch IAW DCL704

I hereby certify that the product identified above has been manufactured in accordance with the applicable design data and the Canadian Aviation Regulations or applicable foreign regulations.

Oct 19/09 Jeff Clark.
Date Inspector's Signature

AERO Design Ltd.
2013 - 39th Ave. NE
Calgary, AB, T2E 6R7

AUTHORIZED RELEASE CERTIFICATE

TRANSPORT CANADA
TCCA 24-0078
AMF # 73-04

Product: Quick Release Cargo Basket (High Mounted) Part #: 76610-01

Approval #: SH00-48 Serial #: 76601-10

WO #: 2008-25 Quantity: 1

Eligibility: Bell 206L Series / 407 Work Status: Manufactured

Remarks: Lid Step and Auxiliary Latch IAW DCL704

I hereby certify that the product identified above has been manufactured in accordance with the applicable design data and the Canadian Aviation Regulations or applicable foreign regulations.

Oct 19/09 Jeff Clark.
Date Inspector's Signature

V1H
AERO Design Ltd.
2013 - 39th Ave. NE
Calgary, AB, T2E 6R7

AUTHORIZED RELEASE CERTIFICATE

TRANSPORT CANADA
TCCA 24-0078
AMF # 73-04

Product: Quick Release Cargo Basket (High Mounted) Part #: 76610-01

Approval #: SH00-48 Serial #: 76601-08

WO #: 2008-25 Quantity: 1

Eligibility: Bell 206L Series / 407 Work Status: Manufactured

Remarks: Lid Step and Auxiliary Latch IAW DCL704

I hereby certify that the product identified above has been manufactured in accordance with the applicable design data and the Canadian Aviation Regulations or applicable foreign regulations.

Oct 14/08
Date

Jff Chla.
Inspector's Signature